

Date: Friday, 3/23/2007 9:23:14 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 31448		
Estimate Number	: 12805		
P.O. Number	: N/A	Part Number	: D35561
This Issue	: 3/23/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3556 UNDER REVIEW
First Issue	: N/A	Project Number	: BP0001
Previous Run	: N/A	Drawing Revision	: U/R
Written By	: <u>JLM 07-03-23</u>	Material	: N/A
Checked & Approved By	: <u>JLM 07-03-23</u>	Due Date	: 3/30/2007
Comment	: Est Rev:A New Issue 07-03-23 JLM	Qty:	2 Um: Each

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0378 sf(s)/Unit Total : 0.0756 sf(s)

304/316 .063 Sheet

Batch: m101873m1 07 03 26

(2)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3556

Dwg Rev: U/RProg Rev: U/Rm1 07 03 26

(2)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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m1 07 03 26

(2)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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JLM 07-03-26

(2)

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3556

2-Tumble

SB 07 /03/24

Tools: w

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 31448

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5



INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**

07.03.26
CB



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1



PACKAGING RESOURCE #1

N/A



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

prototype only

CB 07.03.26

8.0 QC21



FINAL INSPECTION/W/O RELEASE



02
02

Comment: FINAL INSPECTION/W/O RELEASE

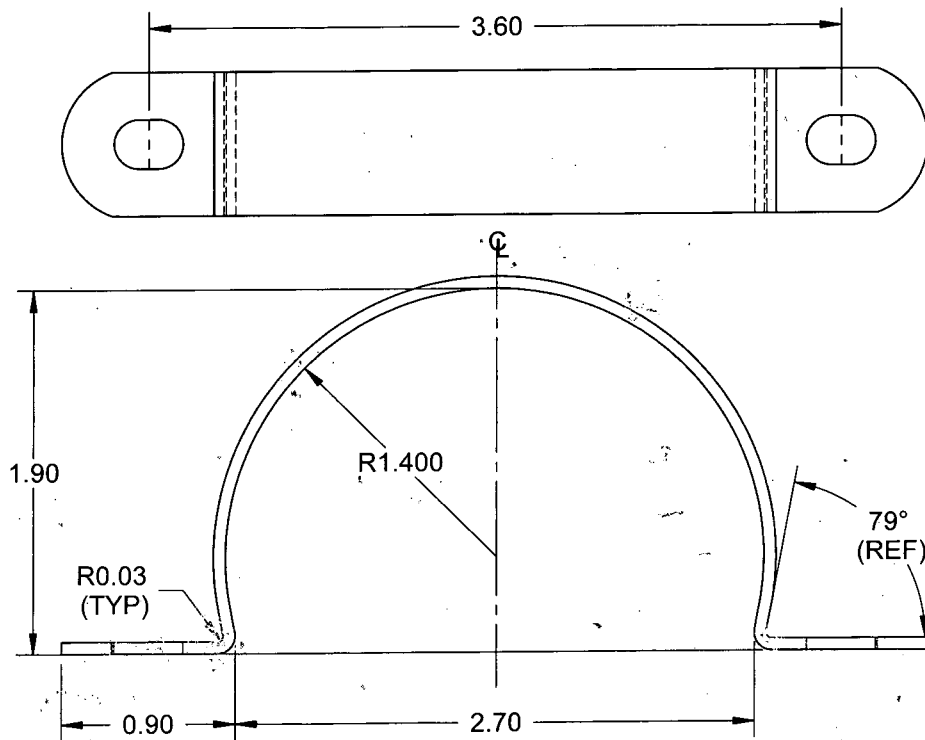
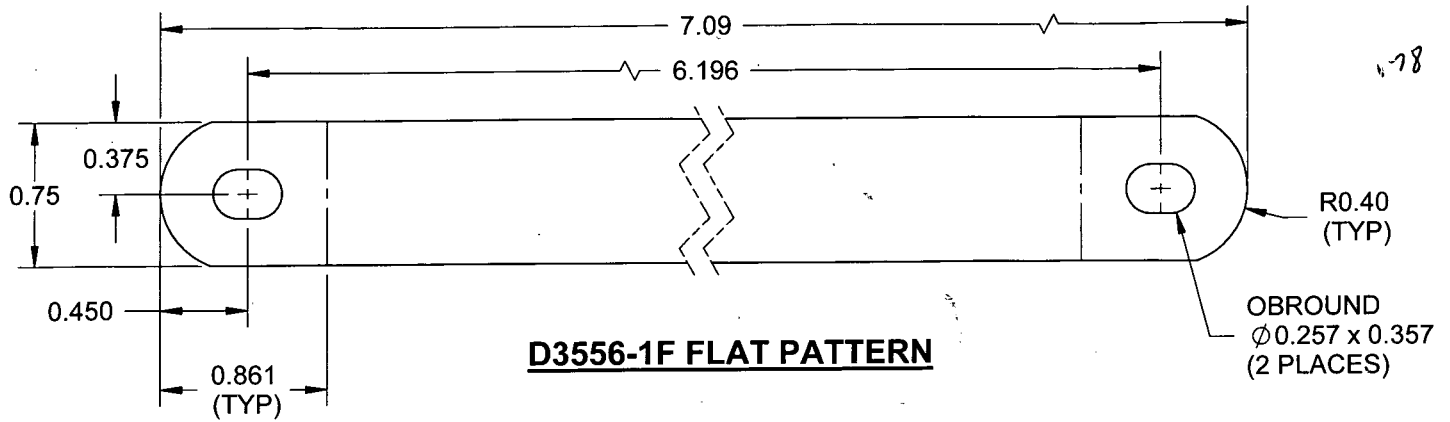
07/03/27

Job Completion



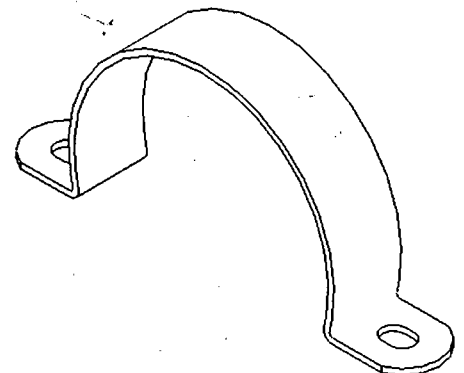
U 07.03.27

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CB	APPROVED CB	DRAWING NO. D3556	REV. A SHEET 1 OF 1
DATE 07.02.13	TITLE CLAMP		SCALE 1:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE, PER MIL-S-5019 (REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N D3556-1 USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT C



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DART AEROSPACE LTD		Work Order: 31448
Description: CLAMP		Part Number: D3556-1
Inspection Dwg: D3556 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 0.257	+0.006 - 0.001	0.257	✓		VERN	
B	0.357	+1 - 0.010	0.357	✓		vern	
C	7.09	+1 - 0.030	7.09	✓		VERN	
D	6.196	+1 - 0.010	6.193	✓		vern	
E	0.455	+1 - 0.010	0.450	✓		VERN	
F	0.75	+1 - 0.030	0.756	✓		vern	
G	0.375	+1 - 0.010	0.378	✓		VERN	
H	R0.40	+1 - 0.030	R0.40	✓		VERN	
I							
J							
K							
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W							
X							
Y							

Measured by: <i>MAI. MAI</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07 03 26	Date: 07 03 26	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	